

**Abstract**

Method for producing a multi-ply web of flexible material, such as paper and nonwoven material, comprising at least one first and one second ply which are interconnected by gluing in a plurality of discrete glue sites. The web is printed with at least one printing pattern which is in register with the glue pattern. The multi-ply web is produced by bringing a first ply in contact with a patterned glue transfer roll, transferring glue to the first ply in a glue pattern, a second ply is brought in contact with the glue applied side of the first ply in a press nip between a patterned lamination roll and an impression roll, the glue transfer roll and the lamination roll being in register with each other and having corresponding patterns.